

Step 1/10

Dart Aerospace Ltd.

Date: Thursday, 10/11/2007 2:54:00 PM
 User: Kim Johnston

Process Sheet

SAC

Customer : CU-DAR001 Dart Helicopters Services
 Job Number : 35115 ✓
 Estimate Number : 10955
 P.O. Number : N/A
 This Issue : 10/11/2007 S.O. No. : N/A
 Prsh Rev. : NC
 First Issue : N/A Type : SMALL /MED FAB
 Previous Run : 31243
 Written By :
 Checked & Approved By : KJ 07.10.11
 Comment : Est: D 01.06.04 Added Powder Coat, Removed Polish, and
 Added Inspection Levels 3 & 21EC

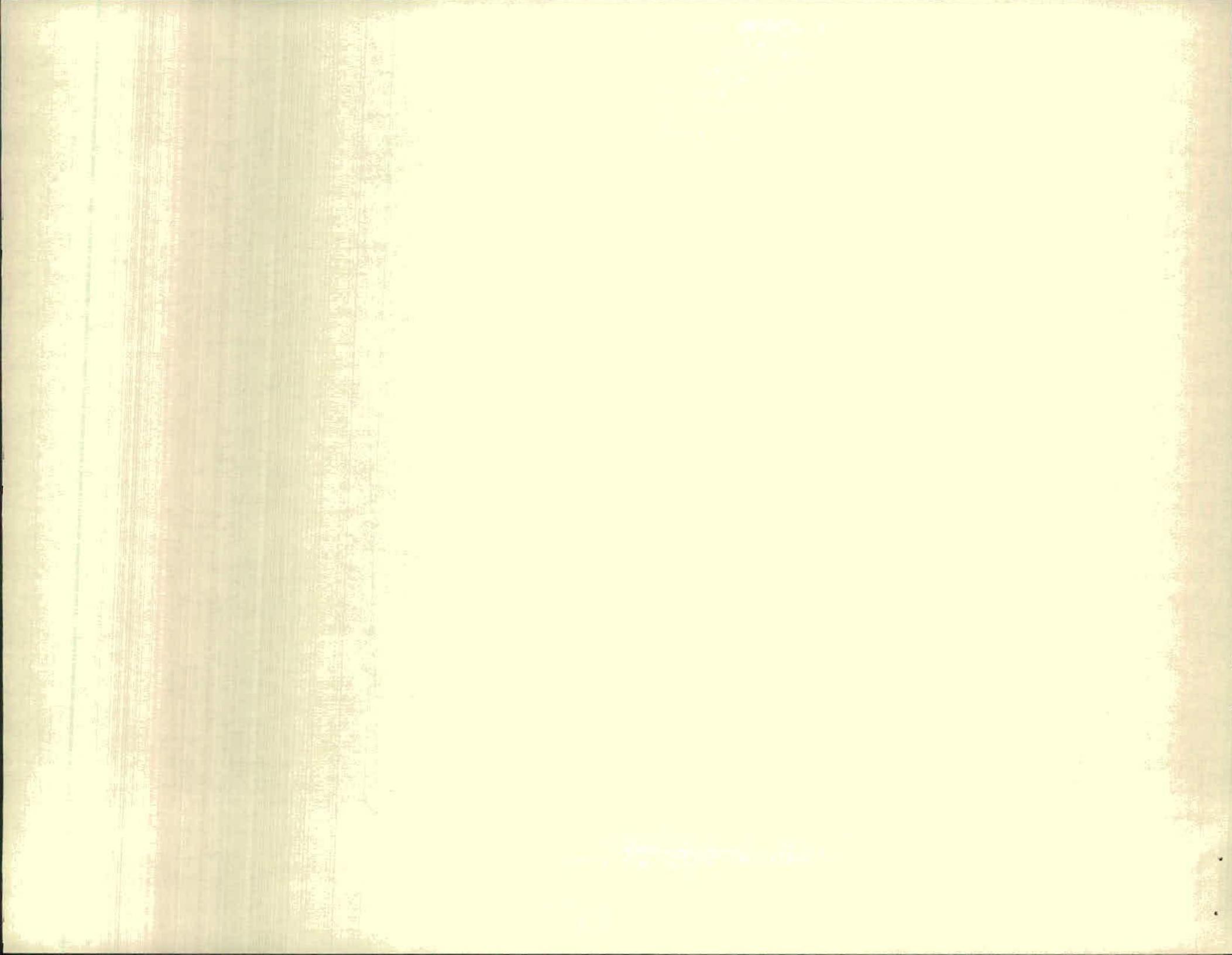
Drawing Name : STRUT
 Part Number : D2565201
 Drawing Number : D2565 REV E
 Project Number : N/A
 Drawing Revision : E
 Material : N/A
 Due Date : 10/17/2007 Qty: 10 Um: Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M304TR0750W049	304 RD Tube .750 x .049W
		Comment: Qty.: 2.0124 f(s)/Unit Total : 20.1243 f(s) Material: 304/316 SS tubing 0.750" Dia. x 0.049" wall (M304TR0750W049) Batch No: M105732 DB 07/10/15
2.0	BRAKE NC	NC BRAKE
		Comment: BRAKE NC Punch as per Dwg D2565 using DT 8313
3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
		Comment: SMALL & MEDIUM FAB RESOURCE 1 Drill hole as per Dwg D2565 (one end only) Deburr
4.0	QC5	INSPECT WORK TO CURRENT STEP
		Comment: INSPECT WORK TO CURRENT STEP
5.0	POWDER COATING	POWDER COATING M105068 3X Comment: POWDER COATING Powder Coat White (Ref: 4.3.5.2) as per QSI 005 4.3
		07/10/17



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Job Number: 35115

Part Number: D2565201

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



1/10/17 SO 3X

Comment: INSPECT POWDER COAT

7.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

7/10/17 SO 3X

8.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

③ 10/10/17

Job Completion

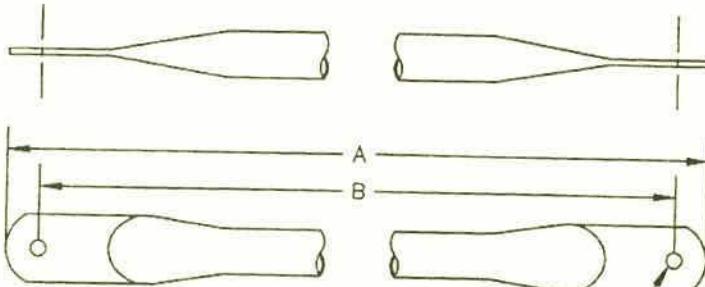


U 10-10-17



DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED	APPROVED	DRAWING NO.	D2565	REV. E
		SHEET 1 OF 1		
DATE	TITLE		STRUT	SCALE
04.05.05				1:3
A	96.05.03	NEW ISSUE		
B	97.03.15	CORRECT D2565-111 DIM. A		
C	98.10.05	UPDATED MATERIAL NOTE (TSR A603)		
D	02.06.05	ADD -3XX PARTS; ADD FINISH		
E	04.05.05	ADD D2565-401-411; RMV ANGLE D		

RELEASED
04.05.05

 DIA 0.257 TO BE PUNCHED
 "C" DIA TO BE OPENED MANUALLY

PUNCH ENDS PER SPEC CONTROL DRAWING D2638

PART #	A	B	DIA C
D2565-101	20.52	19.72	0.316
D2565-103	18.21	17.41	0.316
D2565-105	20.19	19.39	0.316
D2565-107	13.43	12.63	-
D2565-109	12.31	11.51	-
D2565-111	13.65	12.85	-
D2565-201	22.79	22.00	0.316
D2565-203	20.75	19.95	0.316
D2565-205	21.22	20.42	0.316
D2565-207	16.07	15.27	-
D2565-209	15.16	14.36	-
D2565-211	14.14	13.34	-
D2565-301	27.03	26.23	0.316
D2565-303	25.34	24.54	0.316
D2565-305	23.73	22.93	0.316
D2565-307	20.86	20.06	-
D2565-309	20.17	19.37	-
D2565-311	16.30	15.50	-
D2565-401	18.29	17.49	0.316
D2565-403	15.64	14.84	0.316
D2565-405	19.45	18.65	0.316
D2565-407	10.79	9.99	-
D2565-409	9.34	8.54	-
D2565-411	13.81	13.01	-

GENERAL NOTES

- 1) MATERIAL: AISI 304/316/318 SS 0.750 OD X 0.049 WALL
 (REF DART SPEC. M304TR0.750W0.049)
 ENSURE SEAMLESS TUBE IS USED
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3 WITHOUT NOTICE
- 3) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

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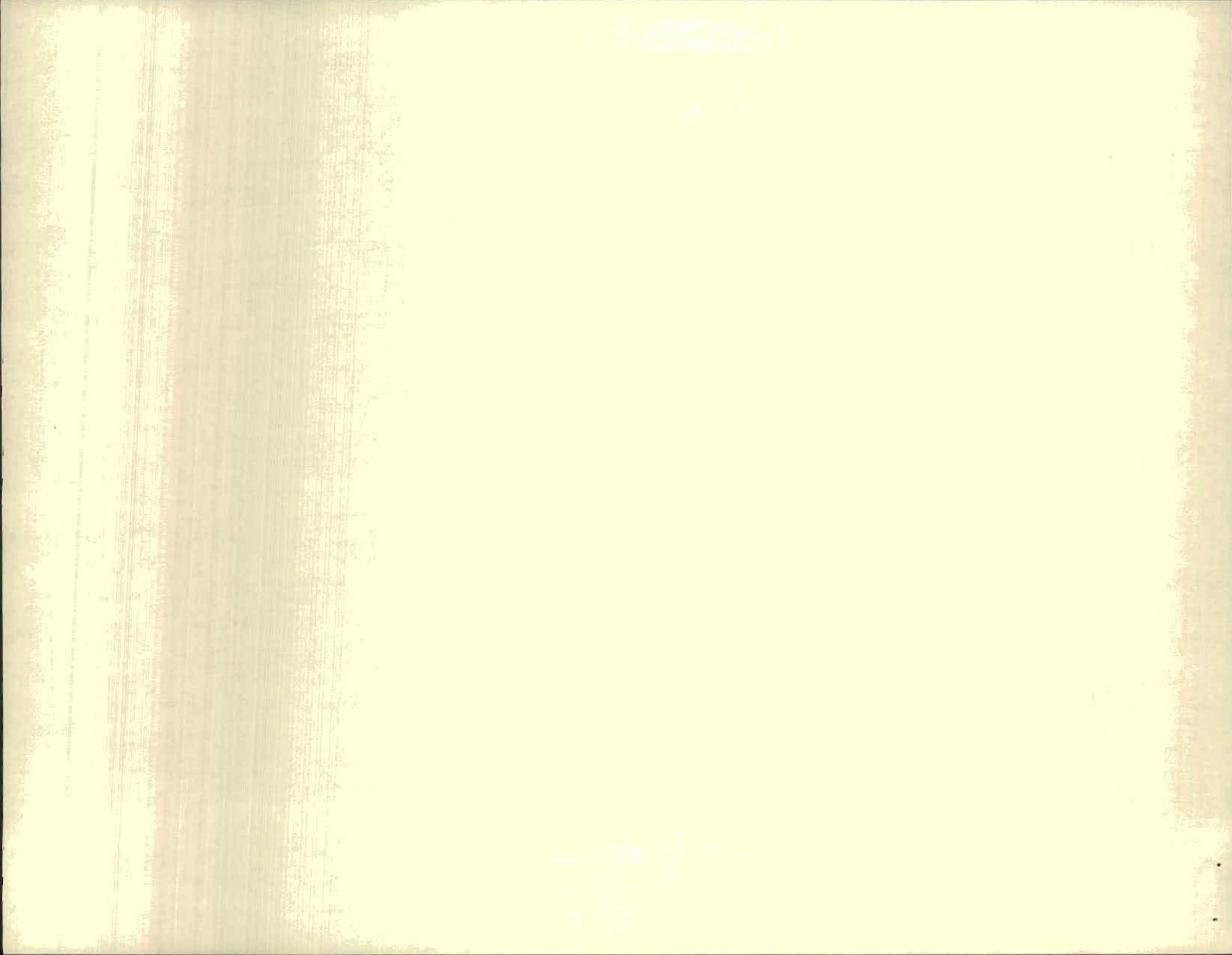
SUBJECT TO AMENDMENT

WORK ORDER

NO. 35115

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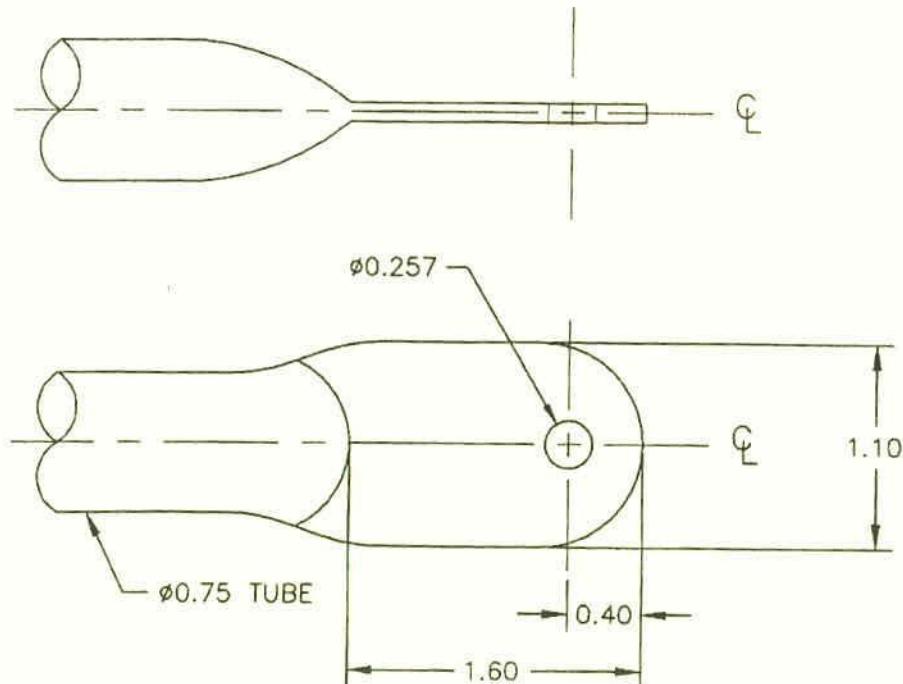


DART

DESIGN KE	DRAWN BY KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>MJ</i>	APPROVED <i>J</i>	DRAWING NO. D2638	REV. A SHEET 1 OF 1
DATE 98.04.28		TITLE PUNCH DT8117 SPEC CONTROL	SCALE 1:1
A	98.04.28	NEW ISSUE	

RELEASED
98/05/05 KE

SPECIFICATION CONTROL DRAWING FOR PUNCH DT8117



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